

Work Order ID 86011

June-19-12 2:22:51 PM

86011

Page 1

Item ID: D212-664-207

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Low Standard Aft

Stop

NS2

Start Date: 19/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D212-664-247

Rev B (DEO)

OSP

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-664-207 CHG002

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

Packaging

120

0.00

120

BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D212-664-247 using CNC bender program and Folio FT

DA 16
12/07/24

MLJ 12/07/24

Ry 12-6-28

JW 12-7-4
MD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Required Date: 03/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC15- Crosstube Dimensional Check

0.00

130

QC

Memo

0.00

Quality Control

8/12/104

140

0.00

140

Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Drill Rivet holes as per Dwg D212-664-247 using DT8972.***Use T-Pin***

2-Drill pilot holes in tube as per Dwg D212-664-247 using DT8550 and DT8551

3-Ream hole to finish size in tube as per Dwg D212-664-247

****Wear latex gloves****

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247

5-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-247

JW

12-7-5

MO

12-7-5

JW

12-7-5

150

QC 5

****Wear latex gloves****

8/12/106

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Hand Xtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion Memo Chemical Conversion Coat Tube & Cuffs	0.00 0.00							
160 *160* QC Quality Control	QC3-Inspect Part Finish Memo	0.00 0.00							
170 *170* QC Quality Control	QC5-Inspect part completeness to step on W/O Memo	0.00 0.00							

160 ~~QC~~ Wear latex gloves ~~QC~~
1- Clean xtube with Wesh 'n Wipe.

AA 12-7-6

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180 Outsource process - NDT per QSI038 4.1 0.00

180

Outsource2

Outsource process - NDT

PA

Memo

Wear latex gloves

0.00

Liquid Penetrant Inspection as per QSI 038
Issue P/O: *17380* LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

CX 12/07/09 (1)

190 Receive & Inspect for Damage & Mat'l Certs 0.00

190

Packaging

Packaging

Packaging

PA

Memo

Wear latex gloves

0.00

Ensure copy of NDT results attached to work order.

12/7/09 (1)

200 QC5- Inspect part completeness to step on W/O 0.00

200

QC

Quality Control

PA

Memo

Wear latex gloves

0.00

Inspect for damage & ensure results are as per Dwg D212-664-207

12-07-09

*204 ** Wear latex gloves ***

*1- Pressure wash and then use wash in wipe to clean
X tube and cuff before chemical conversion.*

12-7-6

*206 QC? ** Wear latex gloves ***

*DAS
16
9-83*

12/07/09

Dart Aerospace Ltd

W/O: 86011		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/07/06	206	AFTER COMPLETION OF STEP 206 MOVE TO 155, 156, & 157 ONCE COMPLETE MOVE TO STEP 210	PSM A	12/07/06	1	le 12/07/06	DAS 1E 9-8- 12/07/06

Part No: D212-664-207 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

*210 209

CARRY OUT STEP 155, 156, 157

0.00

(155 A8 12-7-6)

210

Crosstubes

Wear latex gloves

0.00

A8 12-7-16

Crosstubes

Memo

1-Rivet and assemble Cuffs with T-Pin in the through bolt holes as per Dwg D212-664-247. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: 122130
exp. Mar 2013

215

QC5- Inspect part completeness to step on W/O

0.00

215

QC

Wear latex gloves

0.00

DAS
16
9-89

12/7/16

Quality Control

Memo

Inspect cuff with T-Pin

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

220

SprayPaint

Spray Painting

Spray Painting per QSI005 4.2

0.00

SprayPaint

**** Wear latex gloves ****

Memo

0.00

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME: 121746

Start Time: 11:30

Fininsh Time: 12:00

PAINT: 122381

Start Time: 12:40

Finish Time: 4:30

AP 12-7-16

230

230

QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

Wrap in plastic bag to protect from scratches



7/17/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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1

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Required Date: 03/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

0.00

240

Crosstubes

Crosstubes

Memo

0.00

1- Assemble as per Dwg D212-664-247

1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper,
clean the area with 4105S wash 'n' wipe

2-Install supports with Proseal 890 per DSI9563 and QSI 015

A/R Proseal 890 Batch: 122441

3- Torque bolts as per dwg

AL 12-7-20

250

QC5- Inspect part completeness to step on W/O

0.00

250

QC

Memo

0.00

Quality Control

1 12.07.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 19/06/2012 Start Qty: 1.00

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Required Date: 03/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
255	Pick Kit	0.00							
255									
Packaging	Memo	0.00				1X			SP
Packaging									12-7-24
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270									
Packaging	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D212-664-207								

W/O:		WORK ORDER CHANGES					
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1

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 12/07/25

MK
12-07-25

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Picklist Print

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Page 1

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Parent Item: D212-664-207

D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07.09.12 EC verified by: JLM
 IPP Rev:B ECN 1100p 08-01-11 DD verified by: EC
 IPP Rev:C ECN 1121 08-02-25 DD verified by: ec
 IPP Rev: D QC5 replaced by QC15 at step 5 KJ Verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664- 207TRNRevA		Manufactured	No	79680		110	Each	0.0000	1	①			
										**			
D212-664-207TRNRevA													
Crosstube Turning Detail													
D3660-1		Manufactured	No			140	Each	16.0000	2	2			
										**			
D3660-1													
CUFF													

ZM 12-6-28

<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>
LG		4	
	80359	4	
ST482		12	
	53501	1	
	76983	11	
CR3212-4-06	Purchased	No	220
		Each	202.0000
			44
			**

CR3212-4-06

CHERRY RIVET

122378

JW 12-7-4

AL 12-7-16

JW 12-7-4

AL 12-7-16

122378

Location	Loc Qty	Loc Code
ST330	149	
120521	149	
ST331	53	
112492	18	
112794	8	
119717	27	

② ③ ⑤

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D212-664-207

Parent Item Name: Crosstube Low Standard Aft

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3595-063-530

Manufactured No

240

Each

173.0000

4

4

D3595-063-530

RUBBER CUSHION

**

AP 12-7-20

Location

Loc Qty

Loc Code

LG

134

79932

54

82656

80

MAT052

39

63407

6

67185

6

70067

18

72745

2

75783

7

D2940-1

Manufactured No

240

Each

33.0000

2

2

D2940-1

Support

**

AP 12-7-20

Location

Loc Qty

Loc Code

LG052

33

79118

13

82657

20

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86011

D212-664-207

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21920-28

Purchased

No

240

Each

59.0000

4

4

MS21920-28

Clamp(per MIL-DTL-8783C)

**

18 12-7-20

Location

Loc Qty

Loc Code

FG

5

105884

5

LG050

46

116839

2

118713

4

120054

2

121067

38

LG051

8

121440

8

D3428-1

Manufactured

No

255

Each

35.0000

1

D3428-1

Placard

**

SP

Location

Loc Qty

Loc Code

ST042

35

78933

2

81881

11

83582

10

85228

12

1X

MS21042L6

Purchased

No

255

Each

548.0000

6

MS21042L6

Nut

**

SP 12-7-24

Location

Loc Qty

Loc Code

ST300

548

117677

25

118384

3

118927

48

119075

272

120308

200

6X

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Shop Packet Print

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D212-664-207

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD616

NAS1149D0663J

Purchased

No

255

Each

0.0000

18

18

AN960JD616

Washer

AN6-40A

Purchased

No

255

Each

140.0000

4

4

AN6-40A

Bolt

Location

Loc Qty

Loc Code

ST342

140

120187

66

120833

4

121584

20

121827

50

AN6-41A

Purchased

No

255

Each

73.0000

2

2

AN6-41A

Bolt

Location

Loc Qty

Loc Code

ST342

73

120423

43

121825

30

**

**

**

m121708

SP

4X

SP 12-7-24

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

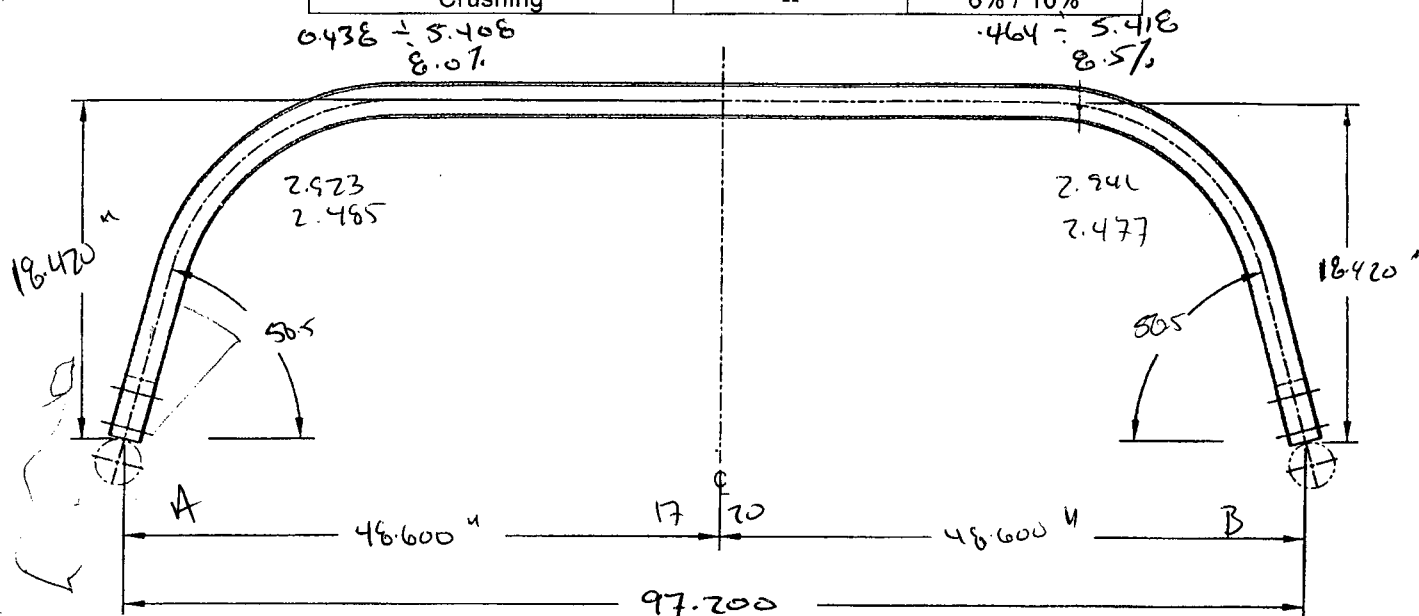
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86011
Description: Crosstube Low Aft (205/212)		Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62
Bending Passes	8	--
Crushing	--	6% / 10%



	Side A	Side B
Bending Passes	17	20
Crushing	8.0%	8.5%
Comments		
Cut Bottom of laser marking.		

QC15 Inspection	8
Date	17/07/04

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	
B	10.04.01	Dwg Rev updated	KJ	
C	12.04.16	Added bending, crushing dimensions	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -247	Qty -247B	Part Number	Description
1	X		D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
2		X	D212-664-247B	CROSSTUBE ASSEMBLY (214 LOW AFT)
3	1	1	D6008-132	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	2	2	D3660-1	CUFF
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6008-132
FINISHED LENGTH = 128.268±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-247 = 36.6 lbs (PER IIN-D212-664)
D212-664-247B = 36.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD
BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6%
BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.
DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE
UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS
NOT BOTTOMED-OUT AFTER TORQUING.
- 16) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF
SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE.
SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

DEO ATTACHED

11-614

11.07.29

UNDER REVIEW

RELEASED
2009-10-29

AMP

B	REVISE GENERAL NOTES/PART LIST; UPDATE TO CURRENT STANDARDS: ADD -247B (ZN C4-2, D5-2)	RF	09.09.30
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	RF	D212-664-247	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE (205/212 LOW AFT)	NTS
DE APPR.	RF	DATE 09.09.30	

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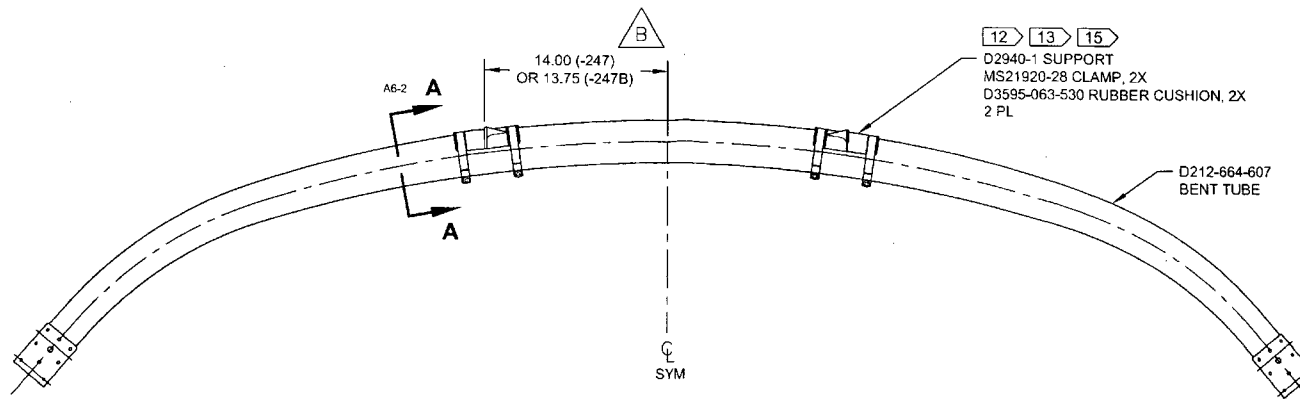
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

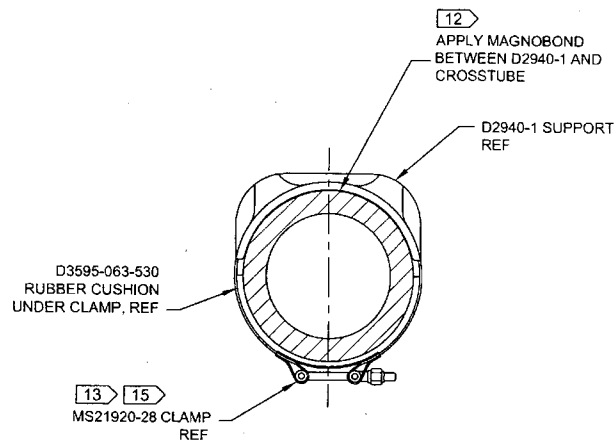
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D212-664-247/-247B
ASSEMBLY DETAIL**



**SECTION A-A D6-2
SCALE 4X**

DEO ATTACHED

600 # 11.646
11.07.26

UNDER REVIEW

RELEASED
2009-10-29

DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	98	D212-664-247	SHEET 2 OF 4
APPROVED	99	TITLE	SCALE
DE APPR.	10	CROSSTUBE (205/212 LOW AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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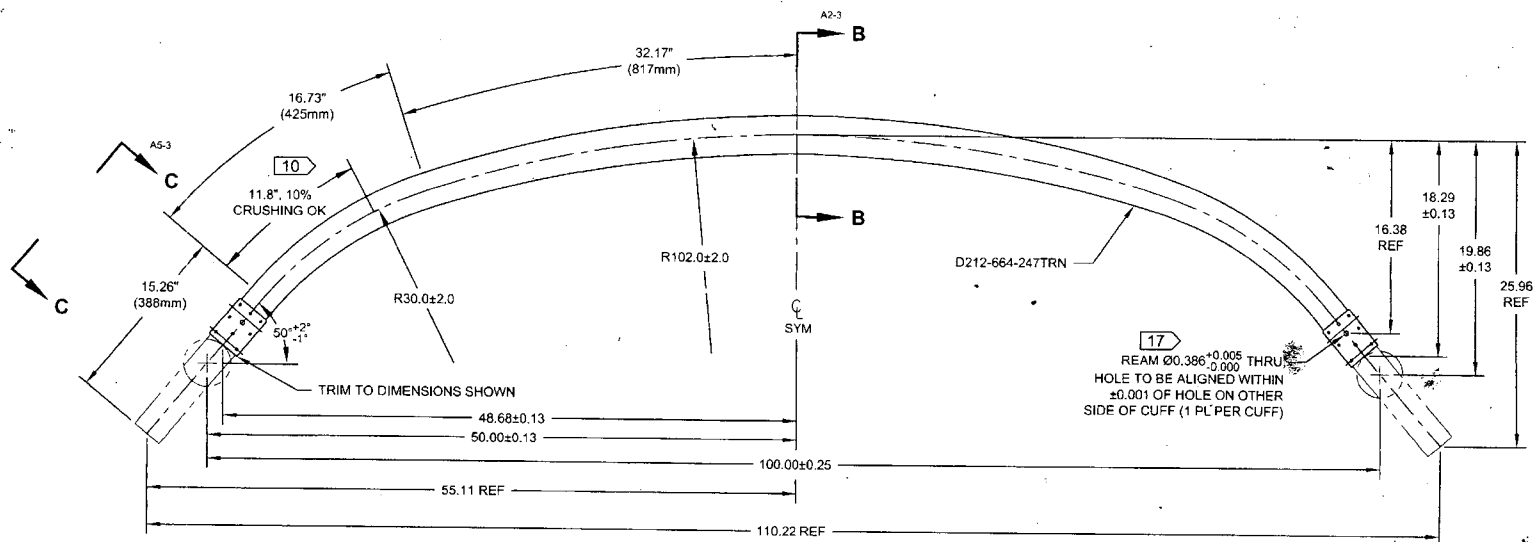
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

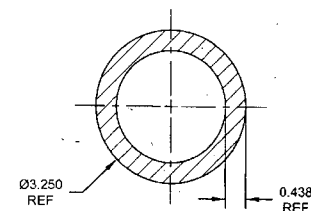
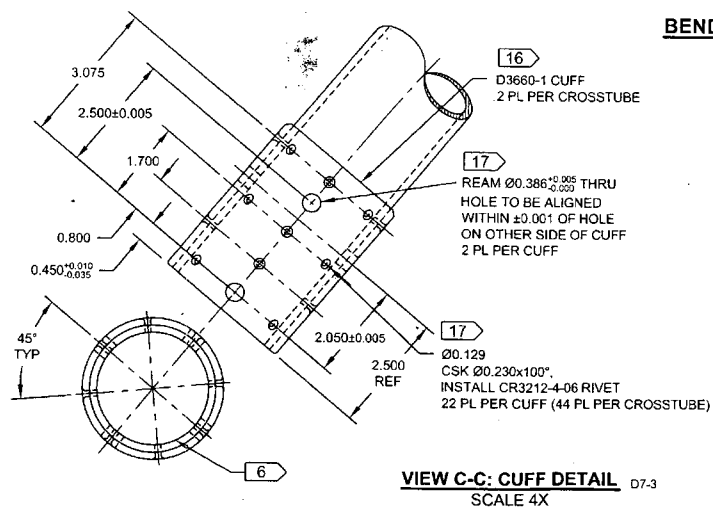
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D212-664-607
BENDING AND DRILLING DETAIL



SECTION B-B D4-3
 SCALE 4X

DEO ATTACHED

UNDER REVIEW

4/11.06.13

RELEASED
 2009-10-29

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D212-664-247	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (205/212 LOW AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

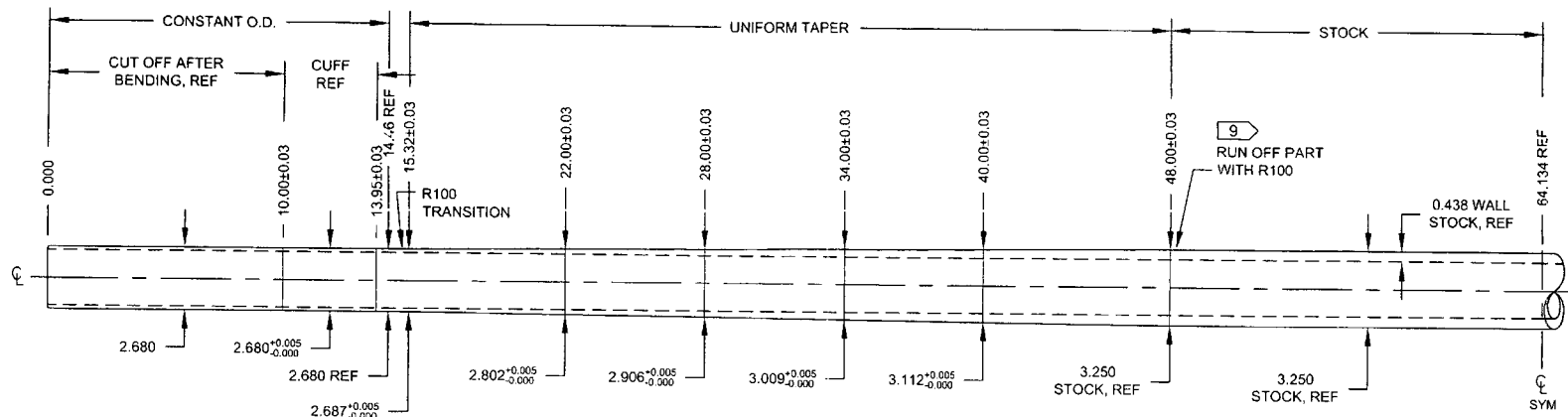
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D
C
B
A



D212-664-247TRN
TURNING DETAIL

DEO ATTACHED

ECU #11-64
11.07.28

UNDER REVIEW

UP 1.08.13

RELEASED
2009-10-29

DESIGN	40	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	40	DRAWING NO.	REV. B
MFG. APPR.	18	D212-664-247	SHEET 4 OF 4
APPROVED	18	TITLE	SCALE
DE APPR.	18	CROSSTUBE (205/212 LOW AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D212-664-247	TITLE CROSSTUBE ASS'Y (205 LOW AFT)	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-247-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 47	CHECKED ASS	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21		DATE 11.07.21		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -247	Qty -247B	Part Number	Description
9	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2940-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.2 STANDARD GEAR CROSSTUBES

Item	-107	207	-209	Part Number	Description
	X			D212-664-107	CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD FWD
		X		D212-664-207	CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD AFT
			X	D412-664-209	CROSSTUBE INSTALLATION, 412 STANDARD AFT
6	1			D212-664-147	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD FWD
7		1		D212-664-247	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K STANDARD AFT
8			1	D412-664-249	CROSSTUBE ASSEMBLY, 412 STANDARD AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21042-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21042-30)
23		4		AN6-40A	BOLT
24		2		AN6-41A	BOLT
25		6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21042-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			2	* D3189-1	CHAFING SHIELD
45	2			* D3659-1	CUFF
46		2	2	* D3660-1	CUFF
47	44	44		* CR3212-4-06	RIVET (M7885/3-4-06)
48			44	* CR3212-4-07	RIVET (M7885/3-4-07)
50	1	1		D3428-1	PLACARD

*REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-147/-247 OR D412-664-249 ASSEMBLIES ABOVE
 NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AAI
 SKIDTUBES.



LIQUID PENETRANT TEST REPORT

P- 12192

CLIENT

ATTENTION

ADDRESS

PROJECT

ITEM(S) EXAMINED

DATE

ACUREN JOB NO.

PO/WO NO.

WORK LOCATION

ACCEPTANCE STD.

PAGE

OF

TIME

AM

PM

JOB DESCRIPTION

PROCEDURE NO. LT-002 REV./DATE 2008

TECHNIQUE NO. LT-1A42 REV./DATE 2008

PART NO.

SCOPE

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MACNAFLUX		BLACK LIGHT S/N	16459	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²
PENETRANT	2407	MINIMUM DWELL TIME	45	MIN.	<input type="checkbox"/> FLASHLIGHT
PENETRANT REMOVER	H2O	MINIMUM DRY TIME	>10	MIN.	<input type="checkbox"/> TROUBLELIGHT
DEVELOPER	SKD52	MINIMUM DWELL TIME	10	MIN.	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY	OTHER	LABINO
			LIGHT METER S/N	1098866	CAL DUE DATE
			2012.		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input checked="" type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- ☒ METRIC ☐ IMPERIAL

W.O. cross tube			
1	84263	" "	✓
1	84262	" "	✓
1	83088	" "	✓
1	86010	" "	✓
1	86011	" "	✓
1	85056	" "	✓
1	85057	" "	✓

1207097

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE	Andy Sheldon	DTR #	E-63066
TECHNICIAN (SIGNATURE):	M.KE. L. H. STON	REPORT REVIEWED BY:	
NAME (PRINT):	M.KE. L. H. STON	NAME	INITIALS
CGSB LEVEL	SNT LEVEL	CGSB LEVEL	SNT LEVEL
CGSB REG. No	16006	CGSB REG. No	

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PT Sept 2005